

Fig. 1

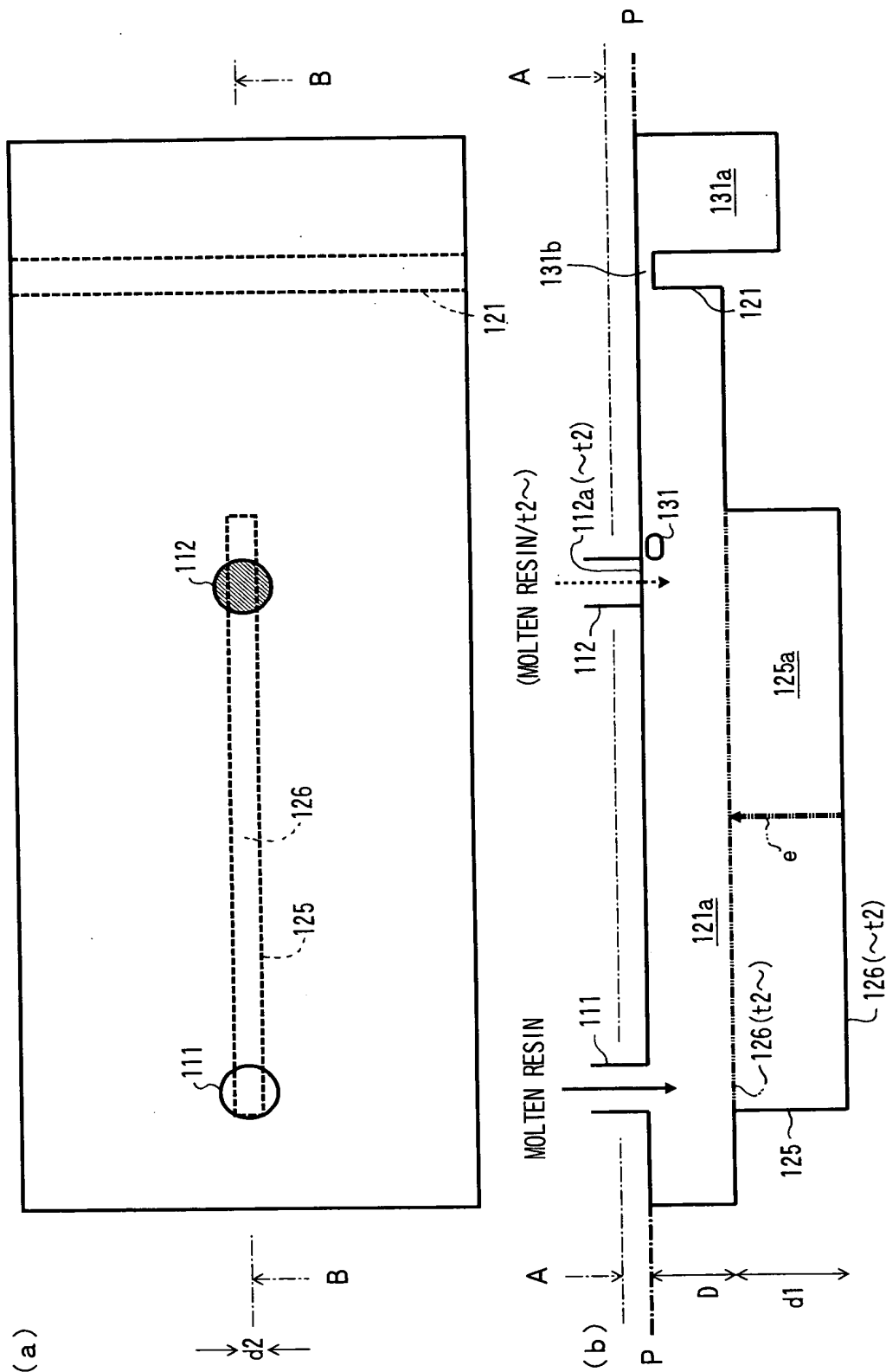


Fig. 2

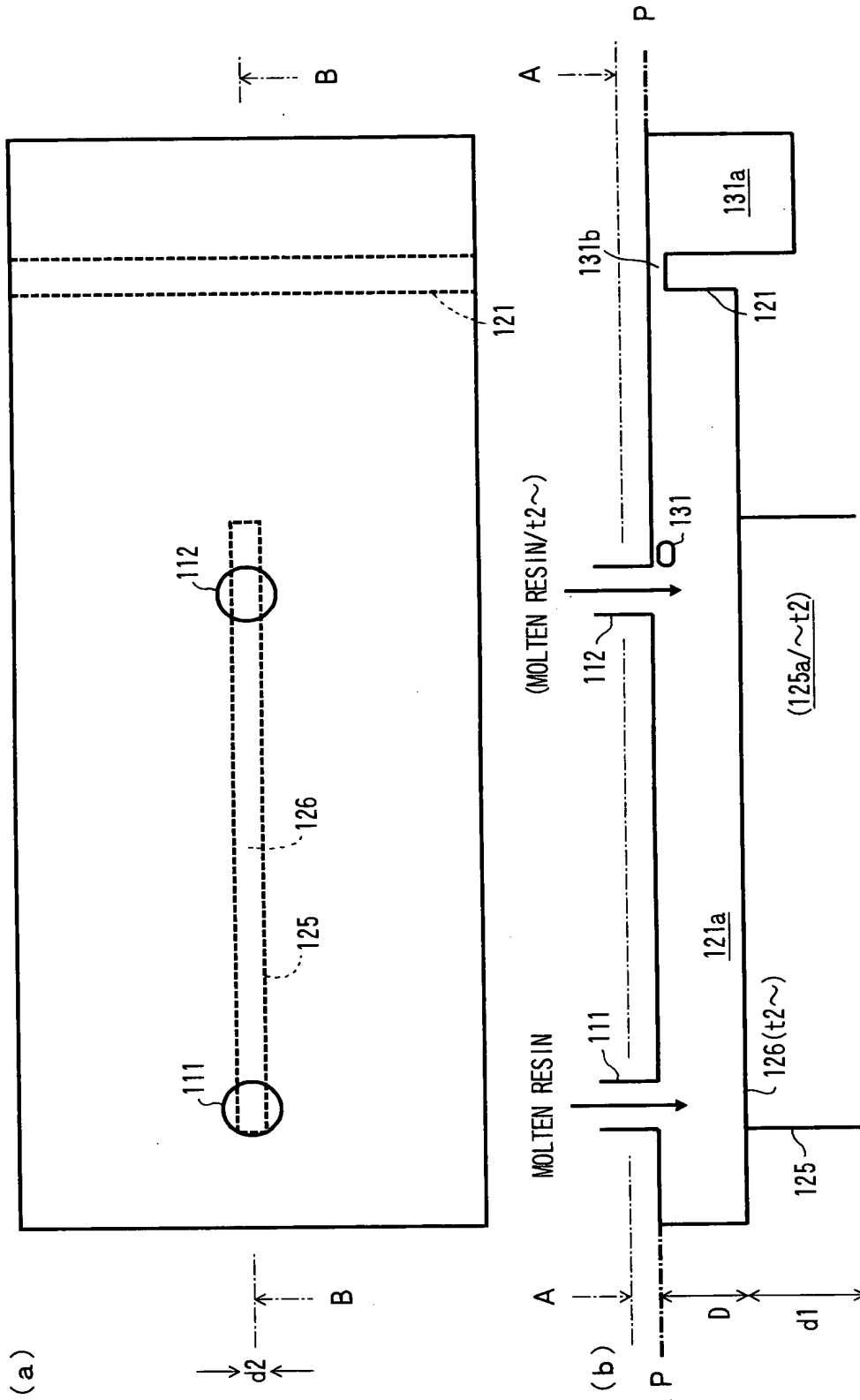


Fig. 3

- $t_1 \sim t_2$ (MELT FRONT OF THE MOLTEN RESIN INJECTED FROM THE GATE 111)
 $t_2 \sim$ (MELT FRONT OF THE MOLTEN RESIN INJECTED FROM THE GATE 111)
 ----- $t_2 \sim$ (THE MOLTEN RESIN INJECTED FROM THE GATE 112)

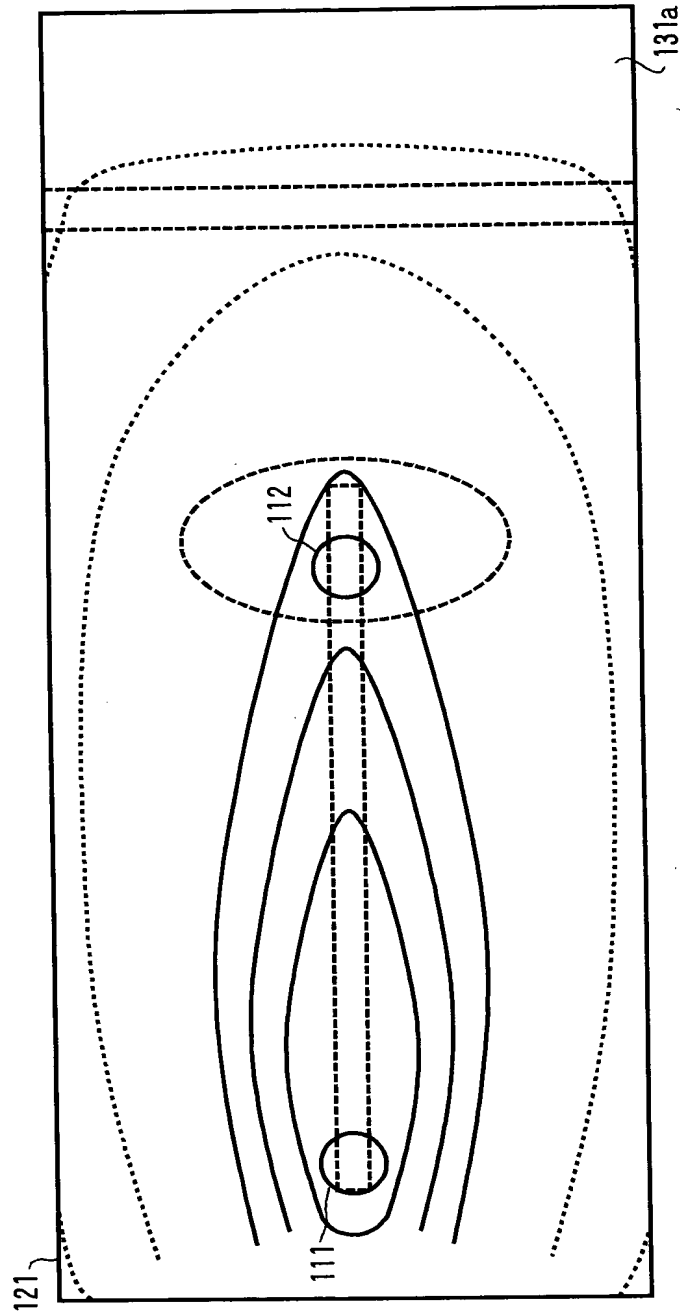


Fig. 4

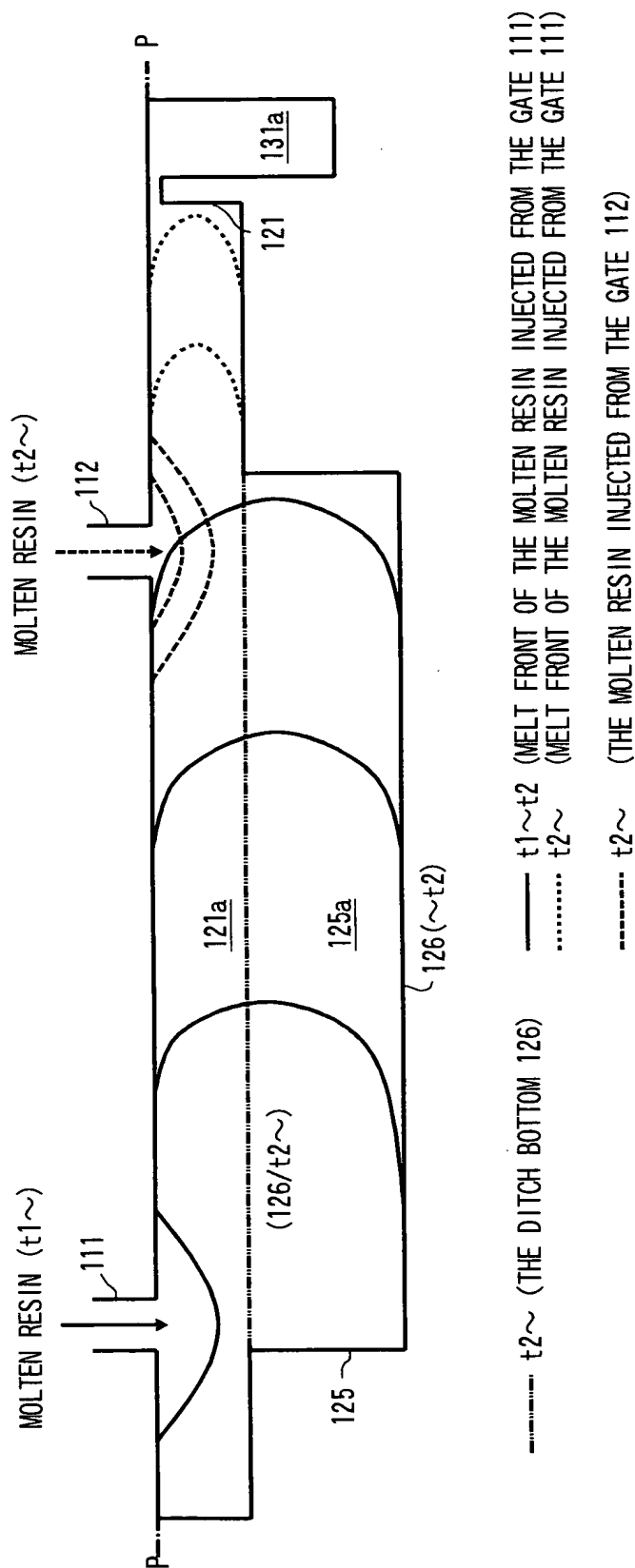


Fig. 5

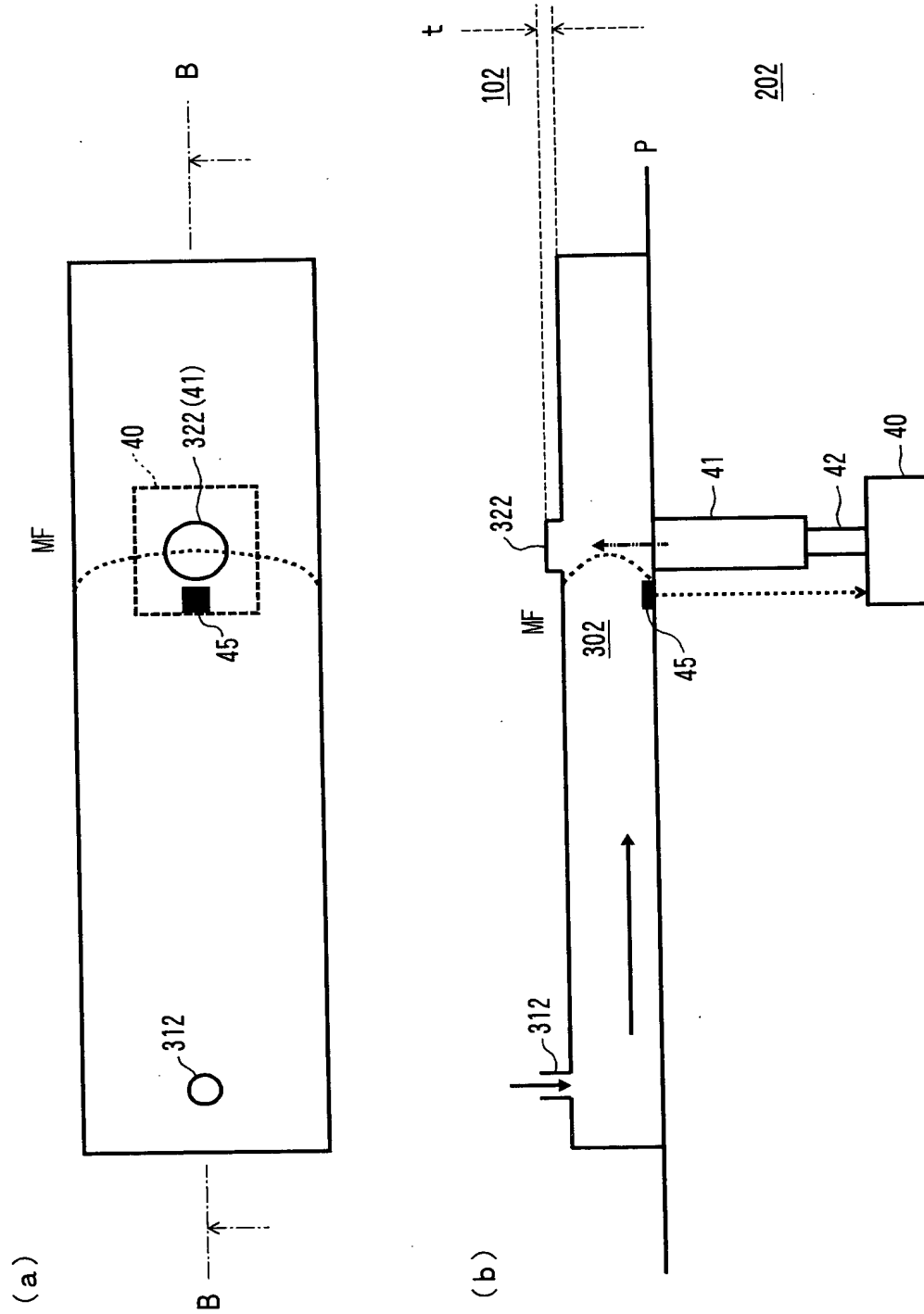


Fig. 6

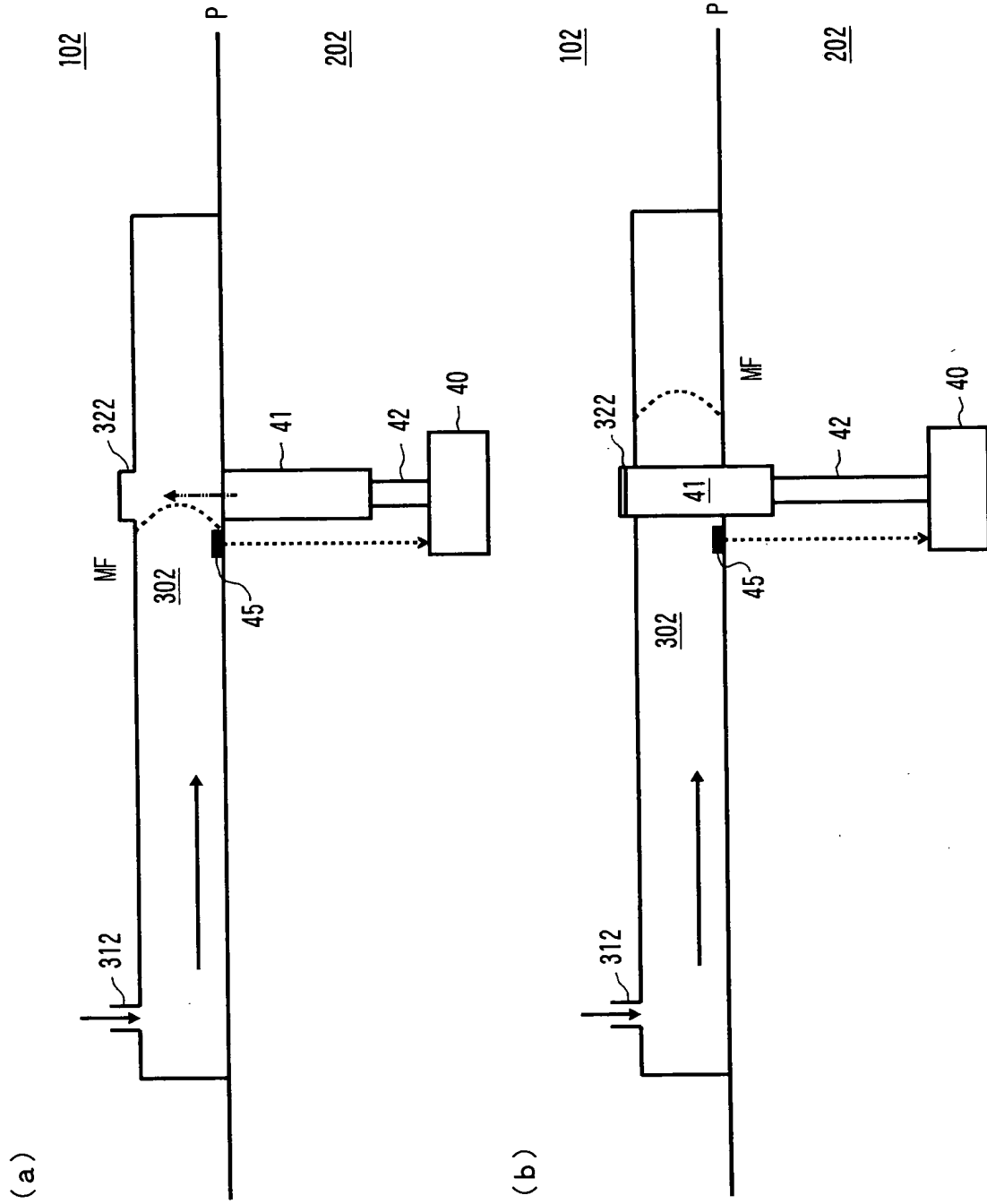


Fig. 7

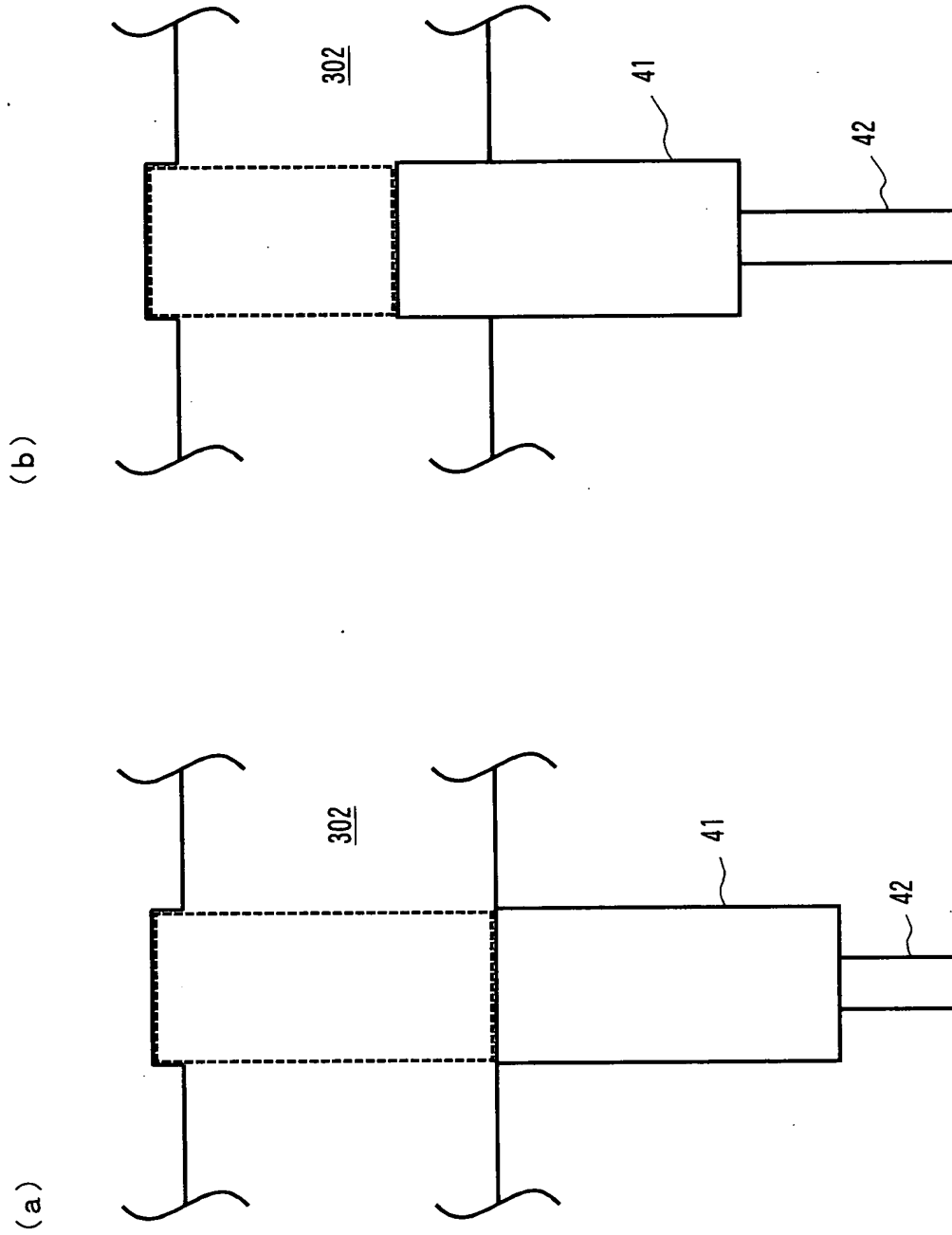


Fig. 8

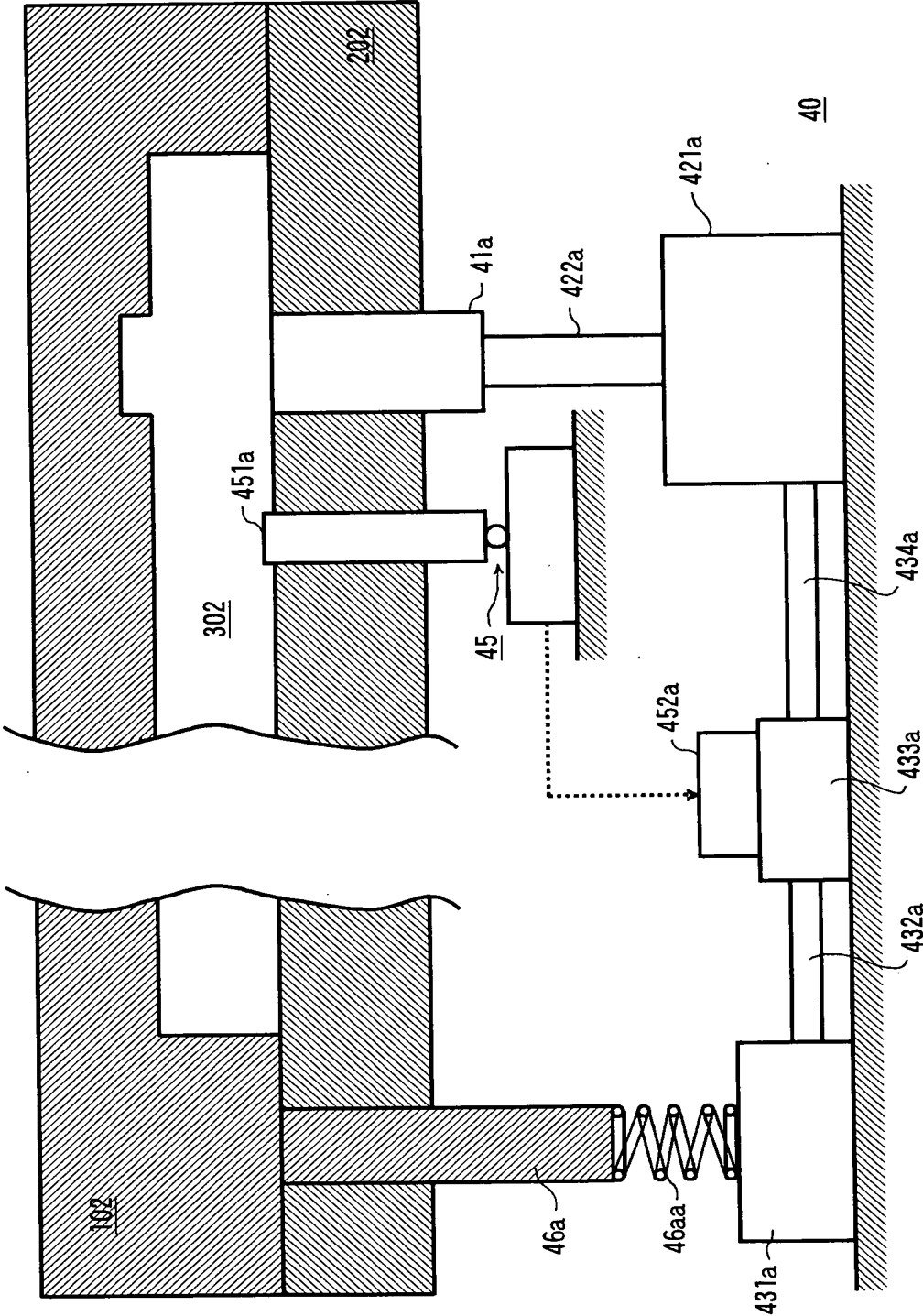


Fig. 9

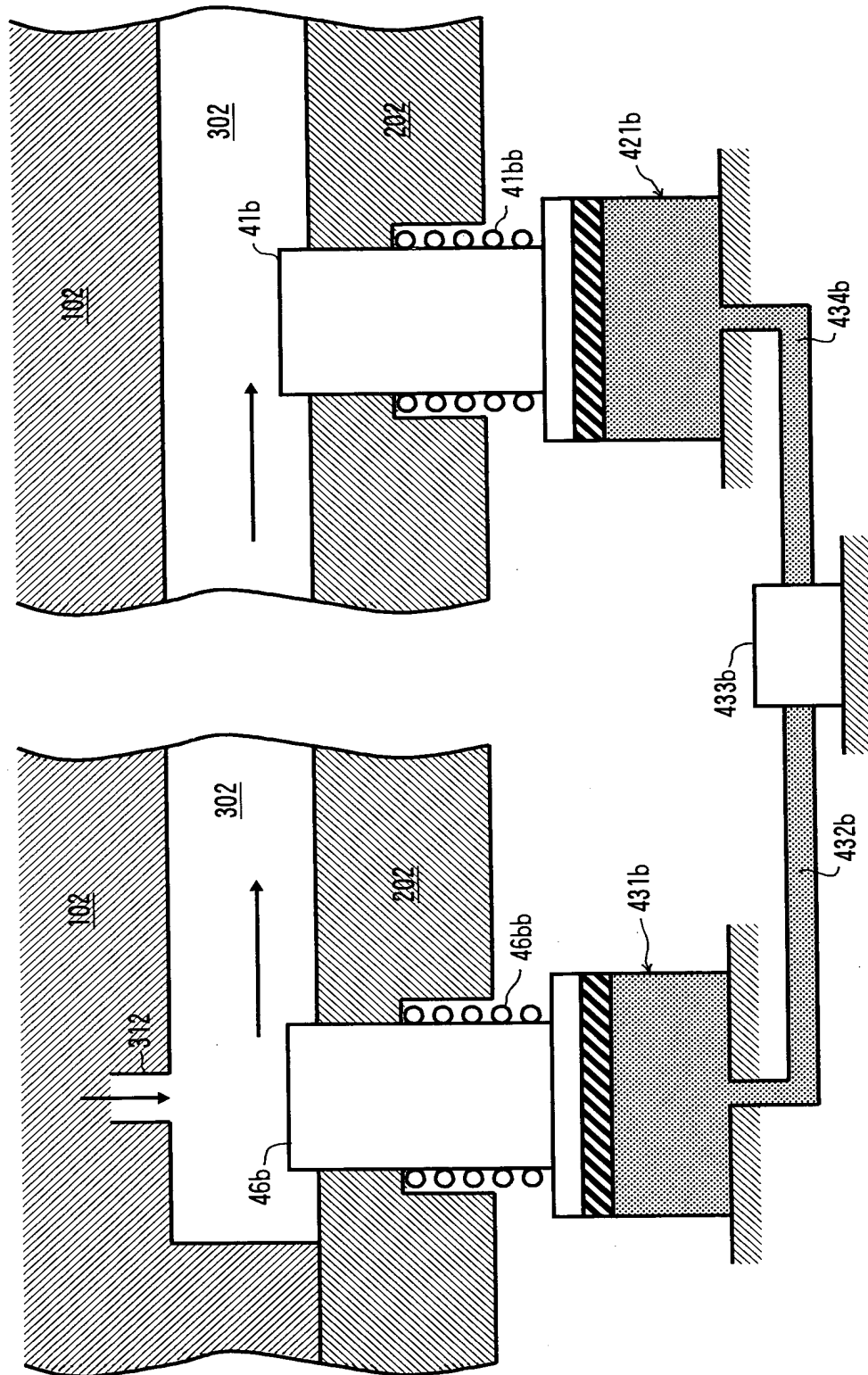


Fig. 10

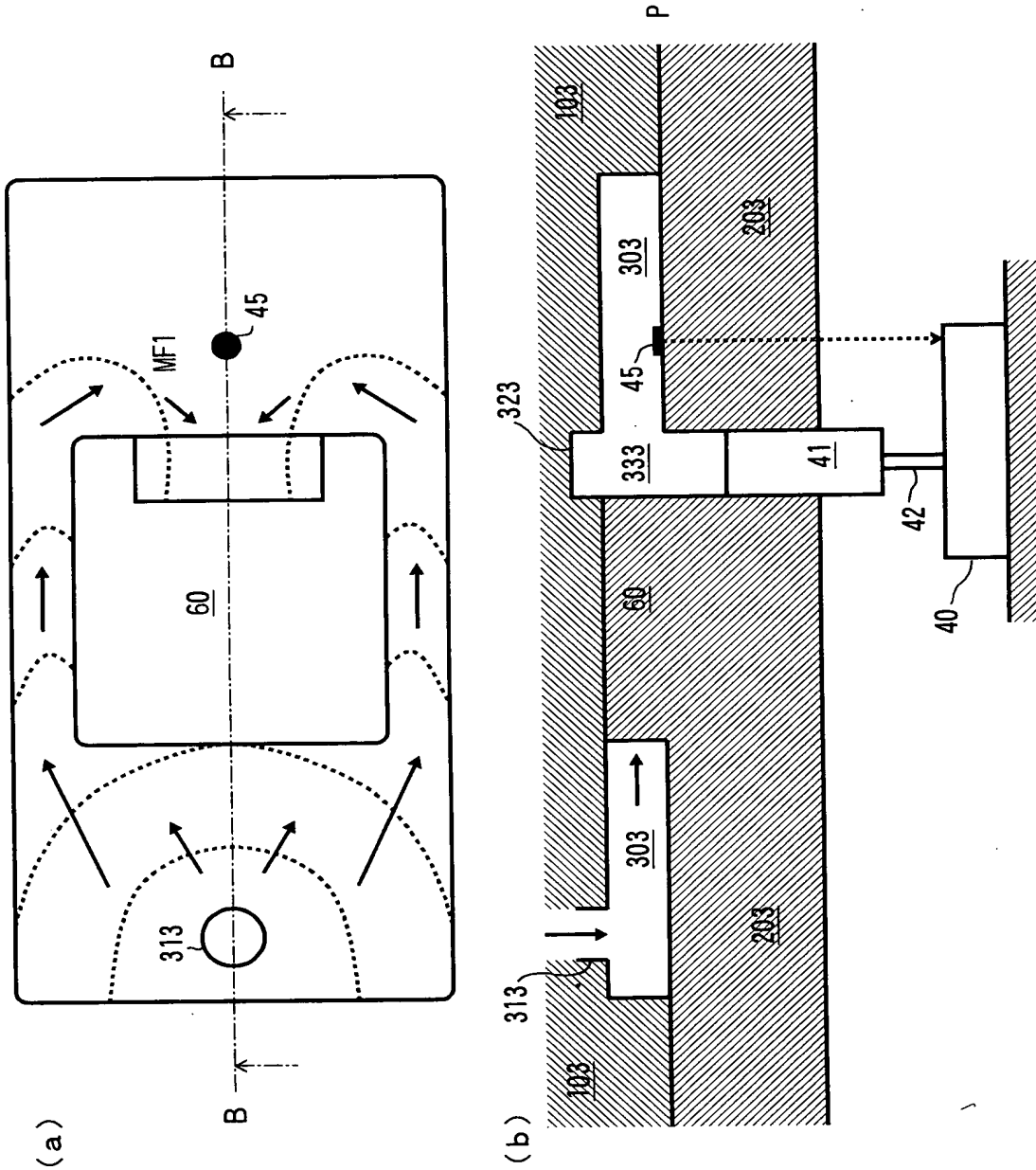


Fig. 11

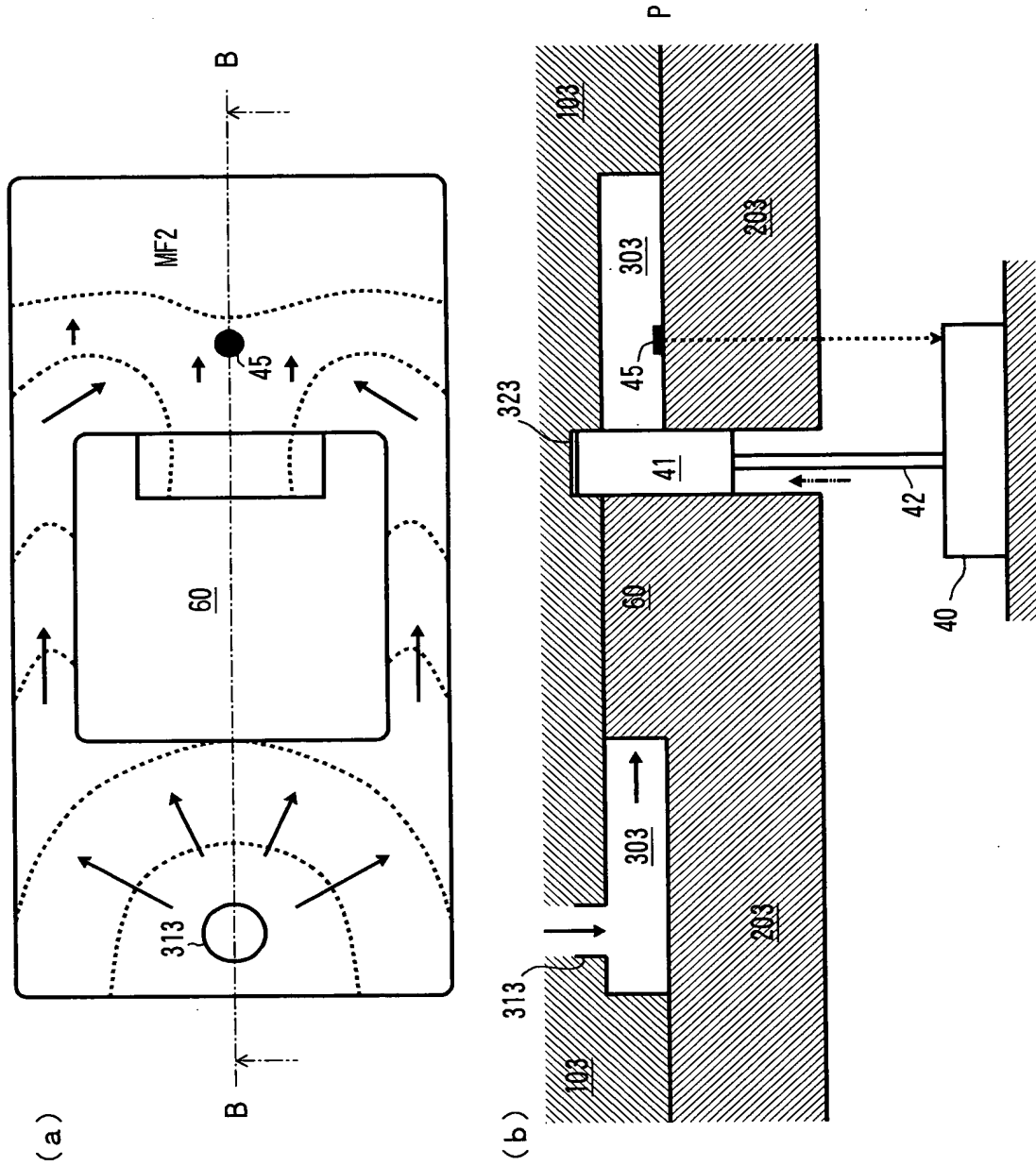


Fig. 12

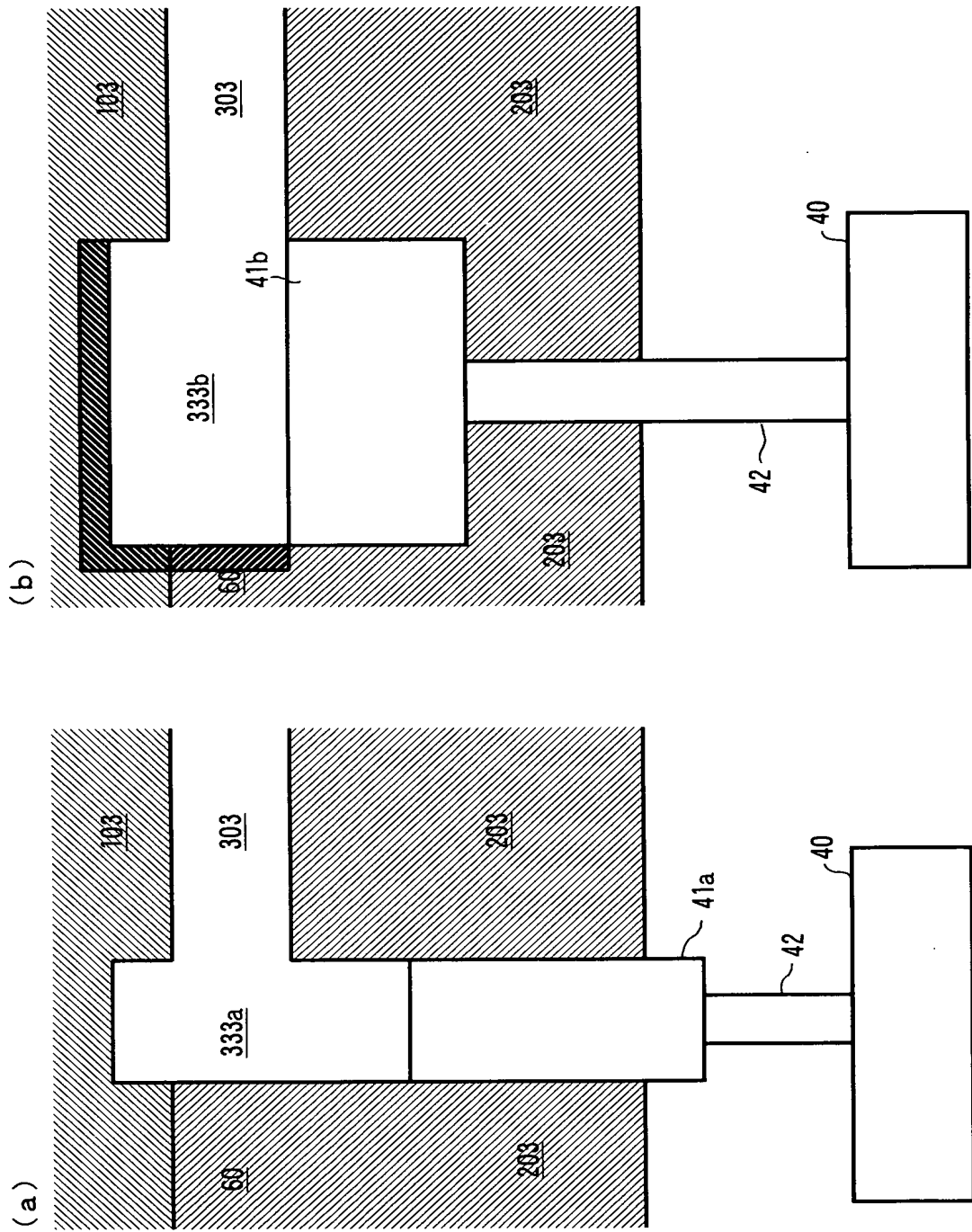


Fig. 13

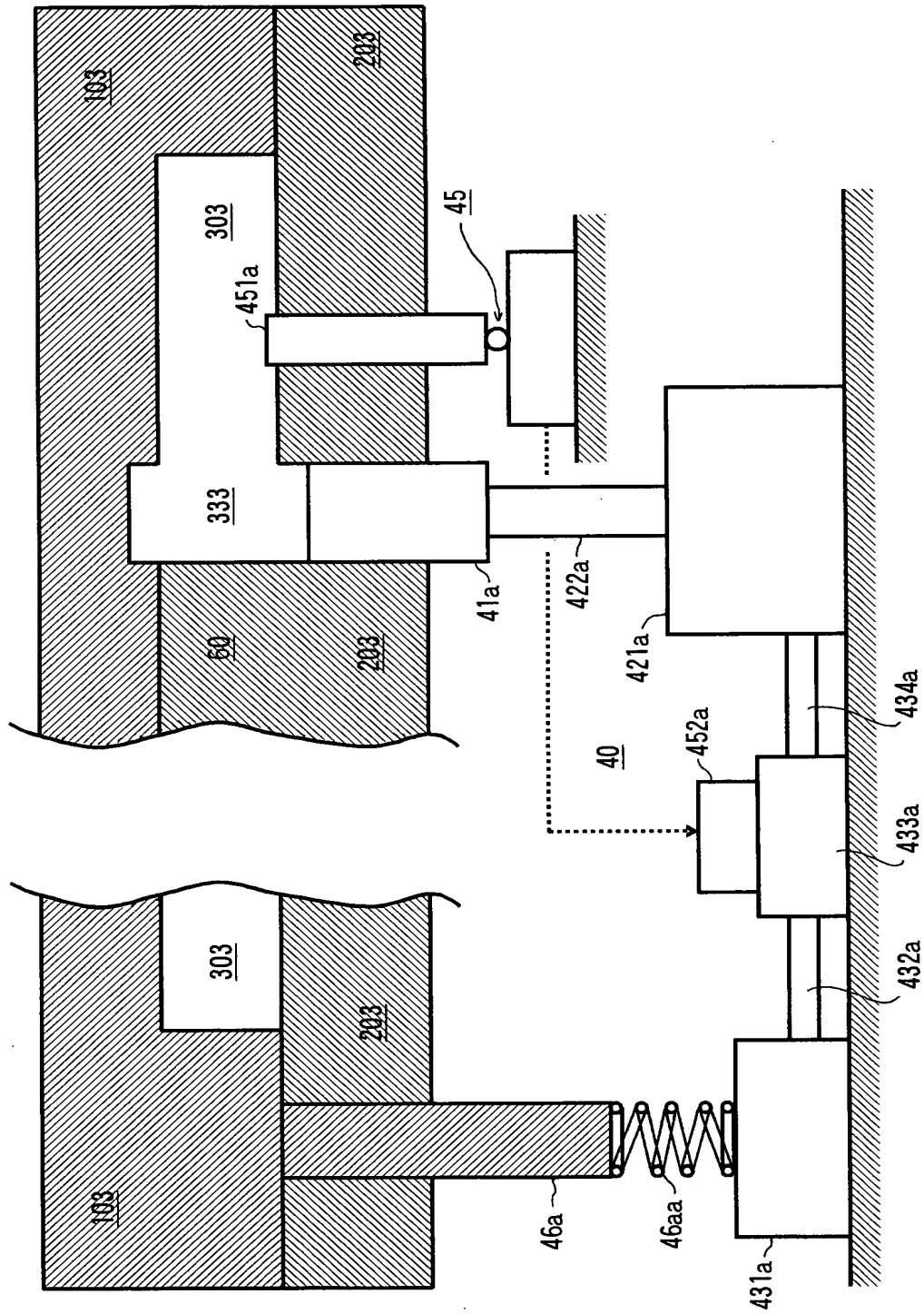


Fig. 14

